

#### Datasheet

#### Description:

AKROMID® B28 GF 30 1 black (4962) is a 30% glass fibre reinforced, heat stabilised and easy flowing polyamide 6 with high stiffness and strength.

#### Applications

Mainly components in mechanical engineering and in the automotive industry.

Typical values	Test specification	Method	Unit	Value d.a.m.
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#### Mechanical Properties

Tensile modulus	1 mm/min	ISO 527-2	MPa	9500
Stress at break	5 mm/min	ISO 527-2	MPa	170
Strain at break	5 mm/min	ISO 527-2	%	3
Charpy impact strength	23°C	ISO 179-1/1eU	kJ/m <sup>2</sup>	65
Charpy notched impact strength	23°C	ISO 179-1/1eA	kJ/m <sup>2</sup>	11

#### Thermal Properties

Melting temperature	DSC, 10K/min	DIN EN 11357-1	°C	220
Temp. of deflection under load HDT/A	1,8 MPa	ISO 75	°C	210
Temp. of deflection under load HDT/B	0,45 MPa	ISO 75	°C	220

#### General Properties

Density	23°C	ISO 1183	g/cm <sup>3</sup>	1,36
Content reinforcement/Content Filler		ISO 1172	%	30

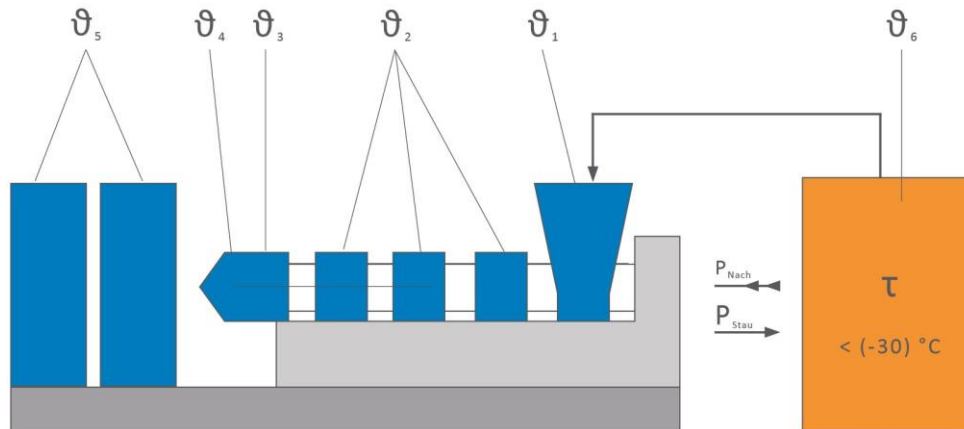
#### Processing

Flowability	7 x 3,5 mm & **	AKRO	mm	830
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\*\* = mould temperature: 80°C, melt temperature: 270°C, injection pressure: 750 bar

#### Continuation

### Processing recommendations



$\vartheta_6$ Drying time	h	0 - 4
$\vartheta_6$ Drying temperature	°C	80
Processing moisture	%	0,02 - 0,1
$\vartheta_1$ Feed section	°C	60 - 80
$\vartheta_2$ Section 1 - Section 4	°C	240 - 290
$\vartheta_3$ Nozzle	°C	260 - 300
$\vartheta_4$ Melt	°C	270 - 290
$\vartheta_5$ Mould	°C	80 - 100
$P_{Nach}$ Holding pressure, spec.	bar	300 - 800
$P_{Stau}$ Back pressure, spez.	bar	50 - 150
Injection speed		medium to high
Screw speed	m/min	8 - 15

The listed values are recommendations. Higher values should be used for higher glass loadings. We recommend only de-humidifying or vacuum dryers. Extensive drying can cause filling problems and surface defects.